

# FLUX CORED WIRE SERIES

## 药芯焊丝系列 ←

E500T-1 E70T-1

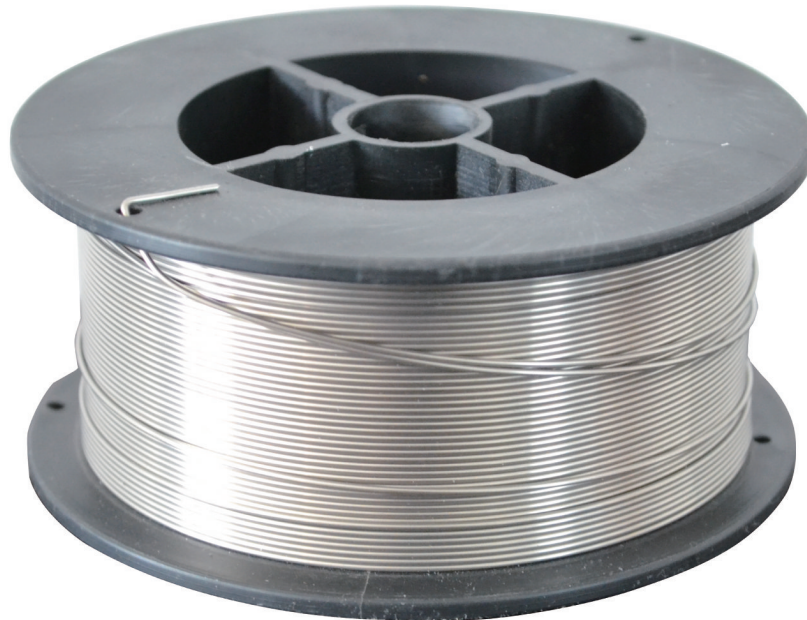
用途：用于焊接，低合金钢和 490Mpa 级高强度钢，通常用于造船，海洋结构，钢结构，桥梁，化工设备等的焊接

符合标准：GB/T：E500T-1      AWS：E70T-1

E500T-1 E70T-1

Purpose: in terms of welding, low alloy steel and 490Mpa grade high strength steel, usually used in shipbuilding, offshore structures, steel structures, bridges, chemical equipment welding

Meet the standard:GB/T:E500T-1      AWS:E70T-1



# 药芯焊丝 E500T-1/E70T-1

符合标准：GB/T：E500T-1 AWS：E70T-1

## 具体参数 Specific Parameters

包装 Package	规格 Specification	丝盘 Wire Tray			重量 Weight
	Φ1.0~1.6(mm)	D100mm D200mm D270mm D300mm K300mm			1 公斤、5 公斤、15 公斤、 18 公斤、20 公斤
焊丝 化学成份 Wire Chemical composition (%)	C	Mn	Si	P	S
	≤0.10	≤1.75	≤0.75	≤0.03	≤0.03
熔敷金属 机械性能 Deposited Metal Mechanical Properties	屈服强度 Yield Strength σ <sub>0.2</sub> (Mpa)	抗拉强度 Tensile Strength σ <sub>b</sub> (Mpa)	延伸率 Elongation δ <sub>5</sub> (%)	AKV 冲击功 AKV Impact Energy (J)	
	≥400	≥480	≥22	≥47(0°C)	
焊丝直径 焊接电流 Diameter of wire(mm) Welding current(A)	φ1.2	φ1.4	φ1.6		
	120~300	160~400	190~450		
注意事项： Matters needing attention:	<p>1. 焊丝进厂后必须存放在干燥环境中，不能随便打开焊丝盘的防水包装</p> <p>2 焊接前应清除焊接面的油、锈、水分等杂质</p> <p>3. 采用 CO<sub>2</sub> 气体保护，CO<sub>2</sub> 气体纯度 99.98%。</p> <p>4 焊接时 CO<sub>2</sub> 保护气体的流量应控制在 20-25L/min。</p> <p>5 焊丝的伸出长度应控制在 15-25mm 范围内。</p> <p>6 焊前需预热至 150-300°C，焊后需经 700-740°C 回火处理。</p> <p>1wire into the plant must be stored in dry conditions, can not open wire reel waterproof packaging</p> <p>2 welding shall be removed before welding surface oil, rust, water and other impurities</p> <p>3 the CO<sub>2</sub>gas protection, CO<sub>2</sub> gas purity99.98%.</p> <p>4 CO<sub>2</sub>welding protective gas flow rate should be controlled at 20-25L/min.</p> <p>5wire extension length should be controlled in the range of 15-25mm.</p> <p>6preheating before welding to weld150-300°C,700-740°C tempering treatment only after.</p>			焊接位置 Welding position	

# FLUX CORED WIRE SERIES

## 药芯焊丝系列 ←

E501T-1, E71T-1

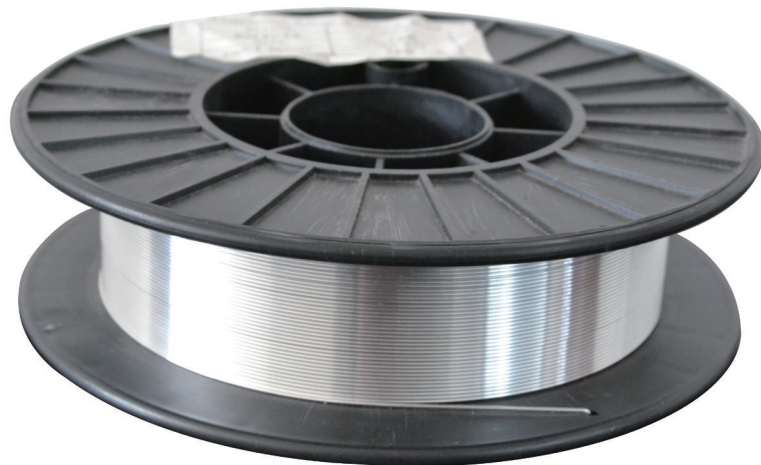
用途属 CO<sub>2</sub> 焊接用钛型药芯焊丝。熔敷效率高，全位置焊接工艺性能佳，亦可立向下焊。适用于船舶、压力容器、机械设备、桥梁等钢结构低钢碳钢和 490MPa 级高强钢的焊接。

符合标准：GB/T：E501T-1      AWS：E71T-1

E501T-1, E71T-1

Use of CO<sub>2</sub> welding titanium type flux cored wire. Cladding of high efficiency, all position welding technology performance, but also vertical downward welding. Applicable to ships, pressure vessels, machinery and equipment, steel structures such as bridges for low carbon steel and 490MPa steel welding.

Meet the standard: GB/T: E501T-1      AWS: E71T-1



# 药芯焊丝 E501T-1/E71T-1

符合标准：GB/T：E501T-1 AWS：E71T-1

## 具体参数 Specific Parameters

包装 Package	规格 Specification	丝盘 Wire Tray			重量 Weight	
	Φ1.0~1.6(mm)	D100mm D200mm D270mm D300mm K300mm			1 公斤、5 公斤、15 公斤、 17 公斤、18 公斤、20 公斤	
焊丝 化学成份 Wire Chemical composition (%)	C	Mn	Si	P	S	
	≤0.10	≤1.75	≤0.75	≤0.03	≤0.03	
熔敷金属 机械性能 Deposited Metal Mechanical Properties	屈服强度 Yield Strength σ <sub>0.2</sub> (Mpa)	抗拉强度 Tensile Strength σ <sub>b</sub> (Mpa)		延伸率 Elongation δ <sub>5</sub> (%)	AKV 冲击功 AKV Impact Energy (J)	
	≥400	≥480		≥22	≥47(0°C)	≥27
焊丝直径 焊接电流 Diameter of wire(mm) Welding current(A)	Φ1.0	φ1.2	φ1.4	φ1.6		
	80~250	120~300	160~400	190~450		
注意事项： Matters needing attention:	<p>1. 焊丝进厂后必须存放在干燥环境中，不能随便打开焊丝盘的防水包装</p> <p>2 焊接前应清除焊接面的油、锈、水分等杂质</p> <p>3. 采用 CO<sub>2</sub> 气体保护，CO<sub>2</sub> 气体纯度 99.98%。</p> <p>4 焊接时 CO<sub>2</sub> 保护气体的流量应控制在 20-25L/min。</p> <p>5 焊丝的伸出长度应控制在 15-25mm 范围内。</p> <p>6 焊前需预热至 150-300°C，焊后需经 700-740°C 回火处理。</p> <p>1wire into the plant must be stored in dry conditions, can not open wire reel waterproof packaging</p> <p>2 welding shall be removed before welding surface oil, rust, water and other impurities</p> <p>3 the CO<sub>2</sub>gas protection, CO<sub>2</sub> gas purity99.98%.</p> <p>4 CO<sub>2</sub>welding protective gas flow rate should be controlled at 20-25L/min.</p> <p>5wire extension length should be controlled in the range of 15-25mm.</p> <p>6preheating before welding to weld150-300°C,700-740°C tempering treatment only after.</p>				焊接位置 Welding position	

# ALUMINUM AND ALUMINUM ALLOY WELDING WIRE SERIES

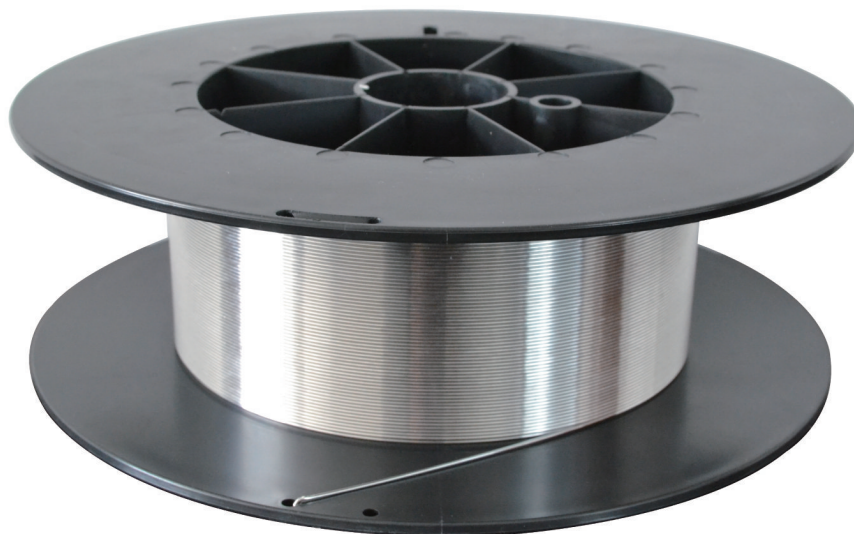
## 铝焊丝系列 ←

说明：我们不仅采购质量优良原材料，而且执行严格的进厂检验，并不松懈的管理生产过程，因此我们能够向客户提供洁净，均匀的铝焊丝。下列各种铝质焊丝都拥有优良的焊接性能，电弧稳定、飞溅少且小，焊缝成型良好，熔敷效率高。

适用保护气体：Ar

Note: we not only procurement of good quality raw materials, and the implementation of strict incoming inspection, not lax management of production process, so that we can provide customers with a clean, uniform aluminum wire. Following various aluminum wire has good welding performance, stable arc, little splash, small, good weld shape, deposition efficiency.

Application of protection gas: Ar



# 铝焊丝

## 具体参数 Specific Parameters

焊丝化学成份 Wire Chemical composition (%)										
类别 Category	牌号 Grade		GB	AWS	性能与用途 Performance and use					
	TIG	MIG			化学成份 (%) Chemical composition (%)					
					Cu	Si	Fe	Mn	Mg	Cr
纯铝用 Pure aluminum	CJ-301	S301	ER1100	塑性好，耐蚀纯铝气焊或氩弧焊用。 Good plasticity, corrosion of pure aluminum gas welding and argon arc welding.						
				0.05~0.20	≤1.0	-	≤0.05	-	-	≤0.10
耐蚀铝 合金用 Corrosion resistant aluminum Alloy	CJ-331	S331	ER5183	强度高，耐蚀性好，铝合金氩弧焊用。 High strength, good corrosion resistance, argon arc welding of aluminum alloys.						
				≤0.10	≤0.40	≤0.40	0.50~1.00	4.3~5.2	0.05~0.25	≤0.25
	CJ-5356	S5356	ER5356	耐蚀性好，强度高，通用性较好，铝合金氩弧焊用，特别适用于 5083 材料的焊接 Good corrosion resistance, high strength, good versatility, argon arc welding of aluminum alloys, especially suitable for 5083 welding materials						
				≤0.10	≤0.25	≤0.40	0.50~0.20	4.5~5.5	0.05~0.20	≤0.10
	CJ-311	S311	ER4043	耐蚀性好，通用性大，铝合金气焊或氩弧焊用，不宜用于高镁合金焊接，用在 4043 材料的焊接效果更好 Good corrosion resistance, large versatility, aluminum alloy gas welding and argon arc welding, is not suitable for high magnesium alloy welding, used in the 4043 material welding effect is better						
				≤0.30	4.5~6.0	≤0.80	≤0.05	≤0.05	-	≤0.10